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DESCRIPTION

STEEL SUPERIOR IN MACHINABILITY AND METHOD OF PRODUCTION OF SAME

TECHNICAL FIELD

The present invention relates to steel used for automobiles, general machinery, etc. and a method of production of the same, more particularly relates to steel superior in machinability which is superior in tool life and cut surface roughness at the time of cutting and chip disposal and a method of production of the same.

BACKGROUND ART

General machinery and automobiles are produced by assembling large numbers of parts. From the viewpoint of the precision requirements and production efficiency, the parts are in many cases produced through a cutting process. At this time, reduction of costs and improvement of production efficiency are required. Improvement of the machinability of the steel is also sought. In particular, conventional SUM23 and SUM24 have been developed stressing machinability. Up to now, it has been known that to improve the machinability, addition of S, Pb, or another machinability improving element is effective. However, some users sometimes avoid use of Pb due to its environmental burden. As a general direction, the amount of use is being reduced.

Up until now, when not adding Pb, the technique has been used of improving the machinability by forming inclusions such as S such as MnS becoming soft in a cutting condition. However, a similar amount of S as with the low carbon and sulfur free-machining steel SUM23 is added to so-called low carbon and lead free-machining steel SUM24L. Therefore, it is necessary to add an amount of S more than the past. However, with addition of a large amount of S, if just making the MnS coarser, not only is it necessary to obtain an MnS distribution

efficient for improving the machinability, but these form starting points of fracture in rolling, forging, etc. and cause many problems in production. Further, in sulfur free-machining steel based on SUM23, the built-up edges easily form causing relief shapes at the cut surface and deterioration of the surface roughness accompanied with detachment of the built-up edges and breakoff of chips. Therefore, from the viewpoint of the machinability as well, there is the problem of a drop in precision due to the deterioration of the surface roughness. In chip disposal as well, it is considered better that the chips be able to be broken short, but with just simple addition of S, the ductility of the matrix is large, so sufficient breakage is not possible and no major improvement can be obtained.

Further, elements other than S such as Te, Bi, and P are known as elements for improving machinability, but the fact that even if improving the machinability to some extent, cracks easily occur at hot rolling or hot forging, so these are preferably made as low in content as possible is disclosed in Japanese Unexamined Patent Publication (Kokai) No. 9-71840, Japanese Patent Application No. 2000-160284, Japanese Unexamined Patent Publication (Kokai) No. 2000-219936, and Japanese Unexamined Patent Publication (Kokai) No. 2001-329335.

Further, Japanese Unexamined Patent Publication (Kokai) No. 11-222646 proposes a method of improving chip disposal by making the establishing the presence of at least 30 sulfides of 20 μm or more alone or groups of sulfides comprised of pluralities of sulfides connected substantially linearly in lengths of 20 μm or more in an observation field of a cross-section of 1 mm^2 in the rolling direction. However, the dispersion of sulfides of the submicron level most effective for machinability in practice, including the method of production, is not alluded to. Further, not much can be expected in view of the ingredients as well.

Further, Japanese Unexamined Patent Publication (Kokai) No. 11-293391 proposes a method of improving the chip disposal by making the average size of the sulfide inclusions 50 μm^2 or less and establishing the presence of 750 or more sulfide inclusions per 1 mm^2. However, the dispersion of sulfides of the submicron level most effective for machinability in practice is not alluded to at all like in Japanese Unexamined Patent Publication (Kokai) No. 11-222646. Further, the technology for deliberately creating this and the method for investigating this are not described either.

On the other hand, cutting tool life tends to be focused on since it has a direct effect on the production efficiency etc., but even in machinability, surface roughness is high in technical difficulty. Surface roughness is affected by the inherent properties of the cut material, so it was difficult to obtain a surface roughness equal to or greater than that of conventional steel. The surface roughness is directly linked with the performance of the part, so deterioration of the surface roughness becomes a cause of decline in part performance or an increase in the defect rate at the time of product production and is often stressed more than tool life. In this sense, conventional lead free-machining steel was superior. Compared with simple sulfur free-machining steel, it is superior not only the tool life, but also the surface roughness, so much use has been made of it for preventing a drop in part performance.

In technology relating to steel for improving the surface roughness, in general free-machining elements such as Pb and Bi are added. In addition, however, for example, as seen in Japanese Unexamined Patent Publication (Kokai) No. 5-345951, for securing a desired surface roughness by making the average size of the MnS inclusions finer to not more than 50 μm^2, graphite free-machining steel superior in tool life and finished surface roughness characterized by containing graphite

having an average cross-sectional area of 5 to 30 μm^2 in an amount of 0.20 to 1.0% in a ferrite matrix has been seen. However, even with these techniques, it is difficult to obtain a surface roughness equal to or better than that of conventional lead free-machining steel. That is, so-called low carbon and lead free-machining steel SUM24L has been superior in surface roughness in the past. The reason is believed to be that the level of fine dispersion of inclusions defined in these only concerns grains of an average size of 3 μm or so, so homogeneous dispersion is insufficient and therefore built-up edges easily are formed and the surface roughness cannot be improved as much as that of conventional lead free-machining steel.

DISCLOSURE OF INVENTION

The present invention provides steel having a good surface roughness and a method of production of the same which avoid problems in hot rolling and hot forging while improving both the tool life and surface roughness and giving a machinability at least equivalent to that of conventional low carbon and lead free-machining steel.

Cutting is a fracture phenomenon of breaking off chips. Promotion of this is one point. In particular, to obtain a good surface roughness, the inventors caused embrittlement of the matrix so as to facilitate fracture and thereby extend tool life and also suppressed nonuniformity in the steel to a minimum so as to cause a fracture phenomenon stable even on the micro level and thereby suppress roughness of the cut surface. Specifically, the inventors took note of the distribution of pearlite in steel and caused C to uniformly disperse as fine pearlite (strictly speaking cementite) in steel so as to cause stable fracture and thereby create a cut surface with no roughness and provided a method of production enabling this. The gist of the present invention is as follows:

According to the present invention, there is

provided a

(1) Steel superior in machinability comprised of, by wt%,

C: 0.005 to 0.2%,
Si: 0.001 to 0.5%,
Mn: 0.2 to 3.0%,
P: 0.001 to 0.2%,
S: 0.03 to 1.0%,
T.N: 0.002 to 0.02%,
T.O: 0.0005 to 0.035%, and

the balance of Fe and unavoidable impurities, said steel satisfying one or both of Mn/S in the steel being 1.2 to 2.8 or an area ratio of pearlite over a grain size of 1 μm in a microstructure of the steel being not more than 5% and a surface roughness Rz of the steel being not more than 11 μm.

(2) Steel superior in machinability characterized by containing, by wt%, C: 0.005% to 0.2%, Mn: 0.3 to 3.0%, and S: 0.1 to 1.0%, by having a density of MnS having a circle equivalent diameter of 0.1 to 0.5 μm at a cross-section parallel to a rolling direction of the steel material, taken from an extraction replica and observed by a transmission electron microscope, of at least 10,000/mm^2, and by having a cut surface roughness Rz of the steel of not more than 11 μm.

(3) Steel superior in machinability as set forth in (1) or (2), said steel characterized by further containing B:0.0005 to 0.05 wt%.

(4) Steel superior in machinability as set forth in (1), said steel characterized by having a density of MnS having a circle equivalent diameter of 0.1 to 0.5 μm at a cross-section parallel to a rolling direction of the steel material, taken from an extraction replica and observed by a transmission electron microscope, of at least 10,000/mm^2.

(5) Steel superior in machinability as set forth in

(1), said steel characterized by further restricting the amount of S to 0.25 to 0.75 wt% and the amount of B to 0.002 to 0.014 wt%, by containing amounts of S and B in a region surrounded by A, B, C, and D shown in FIG. 4 where the contents of S and B satisfy the following equation (1), and by containing sulfides with BN precipitated in MnS:

$$(B-0.008)^2/0.006^2+(S-0.5)^2/0.25^2 \leq 1 \quad \ldots \quad (1)$$

(6) Steel superior in machinability as set forth in (1) or (2), said steel characterized by further containing, by wt%, one or more of,

V: 0.05 to 1.0%,
Nb: 0.005 to 0.2%,
Cr: 0.01 to 2.0%,
Mo: 0.05 to 1.0%,
W: 0.5 to 1.0%,
Ni: 0.05 to 2.0%,
Cu: 0.01 to 2.0%,
Sn: 0.005 to 2.0%,
Zn: 0.0005 to 0.5%,
Ti: 0.0005 to 0.1%,
Ca: 0.0002 to 0.005%,
Zr: 0.0005 to 0.1%,
Mg: 0.0003 to 0.005%,
Te: 0.0003 to 0.05%,
Bi: 0.005 to 0.5%,
Pb: 0.01 to 0.5%, and
Al: ≤0.015%.

(7) A method of production of steel superior in machinability as set forth in any one of (1) to (3), said method of production of steel characterized by casting molten steel having the steel ingredients as set forth in (1), then cooling at a cooling rate of 10 to 100°C/min, hot rolling, then cooling at a cooling rate of at least 0.5°C/sec in a range from an A_3 point to 550°C.

(8) A method of production of steel superior in

machinability as set forth in (4) or (5), said method of production of steel characterized by casting molten steel having the steel ingredients as set forth in (2), then cooling at a cooling rate of 10 to 100°C/min, restricting a finishing temperature of hot rolling to at least 1,000°C, then cooling at a cooling rate of at least 0.5°C/sec in a range from an A_3 point to 550°C.

(9) A method of production of steel superior in machinability as set forth in any one of (1) to (6), said method of production of steel characterized by restricting a heating temperature for adjusting hardness to not more than 750°C after the cooling after the hot rolling.

(10) A method of production of steel as described in any one of (7) to (9), wherein said steel is steel superior in machinability characterized by further containing, by wt%, one or more of,

V: 0.05 to 1.0%,
Nb: 0.005 to 0.2%,
Cr: 0.01 to 2.0%,
Mo: 0.05 to 1.0%,
W: 0.5 to 1.0%,
Ni: 0.05 to 2.0%,
Cu: 0.01 to 2.0%,
Sn: 0.005 to 2.0%,
Zn: 0.0005 to 0.5%,
Ti: 0.0005 to 0.1%,
Ca: 0.0002 to 0.005%,
Zr: 0.0005 to 0.1%,
Mg: 0.0003 to 0.005%,
Te: 0.0003 to 0.05%,
Bi: 0.005 to 0.5%,
Pb: 0.01 to 0.5%, and
Al: ≤0.015%.

BRIEF DESCRIPTION OF DRAWINGS

FIG. 1 is an opticalmicrograph of a ferrite-pearlite

structure of steel according to the present invention.

FIG. 2(a) is an opticalmicrograph of a state of fine diffusion of MnS according to the present invention, while FIG. 2(b) is an opticalmicrograph of a state of presence of crude MnS in conventional steel.

FIG. 3 is a view of the relationship of a pearlite area ratio and surface roughness.

FIG. 4 is a view of an optimal range of an amount of S and an amount of B according to the present invention.

FIG. 5 is a photograph of a TEM replica showing a state of sulfides having MnS as a main ingredient and having BN compound precipitated according to the present invention.

FIG. 6 is a view of the results of EDX analysis of BN.

FIG. 7 is a view of a plunge cutting method.

BEST MODE FOR CARRYING OUT THE INVENTION

The present invention is characterized by causing embrittlement of the matrix so as to obtain a sufficient machinability, in particular a good surface roughness, without adding lead and by adding a large amount of B to obtain good lubrication of the contact surfaces of the tool/cut material. Further, a relatively large amount of S is also added and the ratio of amounts of addition of Mn and S is precisely controlled to cause them to fine disperse. Further, for the microstructure of the steel, the pearlite seen in conventional carbon steel is controlled. That is, this is steel superior in machinability comprised of chemical ingredients, suppressed in the amount of addition of C, suppressed in the precipitation of coarse pearlite, or, in the case of including too much C, suppressed in coarse pearlite grains by heat treatment, that is, suppressed in pearlite bands often seen in natural cooling.

Next, the reasons for limiting the steel ingredients defined in the present invention will be explained.

C is related to the basic strength of the steel and

the amount of oxygen in the steel, so has a great effect on the machinability. If a large amount of C is added to raise the strength, the machinability declines, so the upper limit was made 0.2%. On the other hand, to prevent the generation of hard oxides lowering the machinability and suppress the pinholes in the solidification process or other damage of dissolved oxygen at a high temperature, it is necessary to control the amount of oxygen to a suitable amount. If just reducing the amount of C by blow refining, not only does the cost mount, but also a large amount of oxygen remains in the steel and becomes a cause of pinholes and other problems. Therefore, the lower limit was made a 0.005% amount of C able to easily prevent pinholes and other problems. The preferable lower limit of the amount of C is 0.05%.

Excessive addition of Si produces hard oxides and lowers the machinability, but suitable addition softens the oxides and does not reduce machinability. The upper limit is 0.5%. Above that, hard oxides are produced. At 0.001% or less, softening of oxides becomes difficult and the cost increases industrially.

Mn is necessary for bonding with sulfur in the steel as MnS. Further, it is necessary to soften the oxides in the steel and make the oxides harmless. The effect depends on the amount of S added, but if 0.2% or less, the added S cannot be sufficiently bonded as MnS and the S becomes FeS causing embrittlement. If the amount of Mn becomes large, the hardness of the base material becomes larger and the machinability and cold workability fall, so 3.0% was made the upper limit.

P causes the hardness of the base material to become greater in the steel. Not only the cold workability, but also the hot workability and casting properties fall, so the upper limit has to be made 0.2%. On the other hand, the lower limit value was made 0.001% by elements with the effect of raising the machinability.

S bonds with Mn and is present as MnS inclusions.

MnS improves the machinability, but stretched MnS is one cause of anisotropy at casting. Large MnS should be avoided, but addition of a large amount is preferable from the viewpoint of improvement of the machinability. Therefore, it is preferable to cause the MnS to finely disperse. For improvement of the machinability to at least that of the conventional sulfur free-machining steel in the case of no addition of Pb, addition of at least 0.03% is necessary. On the other hand, if over 1%, not only cannot production of coarse MnS be avoided, but also cracks occur during production due to deterioration of the casting properties and hot deformation properties due to the FeS etc., so this was made the upper limit.

B has the effect of improving the machinability when precipitated as BN. This effect is not remarkable at 0.0005% or less, while the effect is saturated even if B is added in an amount of over 0.05%. If too much BN is precipitated, conversely cracks occur during production due to deterioration of the casting properties and hot deformation properties. Therefore, the range was made over 0.0005 to 0.05%.

In the present invention, the best properties are obtained by limiting the region surrounded by A, B, C, and D in the ellipse shown in FIG. 4 strictly limited in the amount of S and amount of B as explained above to the region of equation (1):

$$(B-0.008)^2/0.006^2+(S-0.5)^2/0.25^2 \leq 1 \quad \ldots \quad (1)$$

N (total-N) causes the steel to harden in the case of dissolved N. In particular, in cutting, it hardens near the cutting edge due to dynamic strain ageing and thereby reduces the tool life, but also has the effect of improving the cut surface roughness. Further, it bonds with B to produce BN and improve the machinability. At 0.002% or less, no effect of improvement of the surface roughness due to dissolved nitrogen or effect of improvement of the machinability due to BN can be observed, so this was made the lower limit. Further, if

over 0.02%, the dissolved nitrogen is present in a large amount, so conversely the tool life is lowered. Further, bubbles are formed in the middle of casting and become causes of defects etc. Therefore, in the present invention, the upper limit was made 0.02% where these deleterious effects become remarkable.

O (total O) forms bubbles during cooling in the case of presence in the free state and becomes causes of pinholes. Further, control is necessary for softening the oxides and suppressing hard oxides harmful to machinability. Further, oxides are utilized as nuclei for precipitation at the time of fine dispersion of MnS. If under 0.0005%, sufficient fine dispersion of MnS is not possible, crude MnS is generated, and there is a detrimental effect on the mechanical properties as well, so the lower limit was made 0.0005%. Further, if the amount of oxygen exceeds 0.035%, bubbles form during casting to cause pinholes, so the upper limit was made 0.035%.

Next, the reasons for limiting the area ratio of pearlite to 5% or less will be explained. In general, if the steel containing carbon is cooled from a transformation temperature or higher, a ferrite-pearlite structure is formed. In the case of steel containing a small amount of C covered by the present invention, if air cooling from a transformation temperature (A_3 point) or more, then cutting out a piece, mirror polishing the inside, then etching by Nytal, it is possible to observe the microstructure as shown in FIG. 1. The black grains are compound structures of ferrite and cementite called "pearlite". Normally, the grains appearing black due to Nytal are harder than the ferrite grains appearing white. In the deformation/fracture behavior of steel, these exhibit behavior locally different from ferrite grains. This impairs the uniform deformation/fracture in the breakage behavior of chips at cutting, so greatly contributes to the formation of built-up edges and

degrades the surface roughness of the cut surface. Therefore, it is important to eliminate the structural uniformity derived from the C. Therefore, the black grains etched by Nytal are deemed to be pearlite grains. If there are too many pearlite grains, structural uniformity occurs and becomes a cause of deterioration of surface roughness, so the area ratio was restricted to not more than 5% and the surface roughness Rz to not more than 11 μm. FIG. 3 shows the relationship between the pearlite area ratio and surface roughness.

Here, details of the method of measurement will be explained. The hot rolled or hot forged steel is cut to a the longitudinal cross-section (L-cross section) and buried in resin. The piece was then polished to a mirror finish and etched by Nytal. The grains (circle equivalent diameter) of 1 μm or more, except the gray MnS, in the steel etched black by Nytal were analyzed by an image processing system to find the area ratio. At the time of the image processing for measurement of the area ratio, the image contrast was adjusted by the "threshold" setting matched with the pearlite appearing black and the inclusions appearing gray (MnS etc.) were erased from the screen so as to measure only the pearlite. The minimum pearlite detectable at this time is about 1 μm. Pearlite of less than 1 μm size does not have any effect on the machinability, so there is no effect even if not detected.

In the present invention, the measurement fields consisted of 20 fields of 0.2 mm^2 (0.4 mm x 0.5 mm) at a power of X400. The pearlite area ratio was calculated for a total area of 4 mm^2.

Regarding Mn/S, it is already known that this has a large effect on the hot ductility and that normally if Mn/S>3, the production efficiency is greatly reduced. The reason is the production of FeS. In the present invention, however, in the low C and high S region, the

inventors discovered that this ratio can be reduced to Mn/S: 1.2 to 2.8. With an Mn/S of less than 1.2, a large amount of FeS is produced, the hot ductility is sharply reduced, and the production efficiency is greatly reduced.

FIG. 2 shows examples of observation of fine MnS in the cases where $Mn/S \leq 2.8$ and $Mn/S > 2.8$ under a transmission type electron microscope using the replica method. When $Mn/S > 2.8$, the result becomes only coarse MnS such as shown in FIG. 2(b) and the surface roughness cannot be reduced. On the other hand, when restricted to Mn/S:1.2 to 2.8, production of fine MnS such as shown in FIG. 2(a) is obtained.

The number of the fine MnS can be increased by repeating a process of continuous casting or ingot casting, then heating to 900°C or more.

Next, the reason for defining the density of MnS of a circle equivalent diameter of 0.1 to 0.5 μm as at least 10,000/mm^2 in the type of MnS and its size and distribution will be explained.

MnS is an inclusion improving the machinability. By causing fine dispersion at a high density, the machinability is remarkably improved. To obtain this effect, it is necessary that the density of MnS of a circle equivalent diameter of 0.1 to 0.5 μm be at least 10,000/mm^2. The MnS sulfides are usually observed in distribution by an opticalmicroscope and measured for dimensions and density. MnS sulfides of these dimensions cannot be confirmed by observation under an opticalmicroscope. They can only be observed first by a transmission type electron microscope (TEM). They are sulfides mainly comprised of MnS of dimensions where a clear difference can be recognized under TEM observation even if there is no difference in dimensions and density under observation by an opticalmicroscope. In the present invention, this is controlled and the form of presence is

converted to numerical values to differentiate it from the prior art.

To establish the presence of MnS exceeding the above dimensions in a density of 10,000/mm^2 or more, it is necessary to add a large amount of S over the range of the present invention. If adding a large amount, there probability rises of a large number of coarse MnS also being present and causing anisotropy at forging. If the MnS exceeds this dimension due to the amount of addition of S in the range defined by the present invention, the amount of MnS becomes insufficient and the density required for improvement of the machinability can no longer be maintained. Further, if a minimum diameter of 0.1 μm or less, there is substantially no effect on the machinability. Therefore, it is necessary that the density of MnS of a circle equivalent diameter of 0.1 to 0.5 μm be at least 10,000/mm^2. To obtain the dimensions and density of MnS, it is more effective to not only control the cooling rate, but also make the ratio of Mn and S contained 1.5 to 2.5.

Further, in the present invention, as shown in FIG. 5 in the above MnS, it is important that the above-mentioned MnS, as shown in FIG. 5, has the form of a sulfide with at least 10 wt% of boronitride (BN) compound precipitated.

BN normally easily precipitates at the crystal boundaries and has difficulty uniformly dispersing in the matrix. Therefore, it is not possible to cause uniform embrittlement of the matrix required for improving the machinability and not possible to sufficiently obtain the effect of BN. For uniform dispersion in the matrix, it is necessary to cause MnS, which forms sites for precipitation of BN and is also effective for improving machinability, to uniformly disperse in the matrix. By making BN and MnS compound precipitate, uniform dispersion of BN is promoted and the machinability is greatly improved. Therefore, it is necessary that at

least 10% of BN compound precipitate with MnS.

The BN referred to here, FIG. 5 showing a TEM replica photograph thereof, indicates a compound of B and N where peaks of B and N are clearly recognized in EDX analysis of FIG. 6.

Note that "MnS" includes not only pure MnS, but also inclusions including mainly MnS and having sulfides of Fe, Ca, Ti, Zi, Mg, REM, etc. dissolved in or bonded with the MnS for copresence, inclusions like MnTe where elements other than S form compounds with Mn and dissolve in or bond with MnS for copresence, and the above inclusions precipitated using oxides as nuclei. It is a general term for Mn sulfide-type inclusions able to be expressed by the chemical formula (Mn,X)(S,Y) (where X: sulfide forming elements other than Mn and Y: element binding with Mn other than S).

Next, in the present invention, in addition to the above ingredients, it is possible to add one or two or more of V, Nb, Cr, Mo, W, Ni, Sn, Zn, Ti, Ca, Zr, Mg, Te, Bi, and Pb in accordance with need.

V forms a carbonitride and can strengthen the steel by secondary precipitation hardening. At 0.05% or less, there is no effect on raising the strength, while if added in an amount over 1.0%, a large amount of carbonitrides is precipitated and conversely the mechanical properties are impaired, so this was made the upper limit.

Nb also forms a carbonitride and can strengthen the steel by secondary precipitation hardening. At 0.005% or less, there is no effect on raising the strength, while if added in an amount over 0.2%, a large amount of carbonitrides is precipitated and conversely the mechanical properties are prevented, so this was made the upper limit.

Cr is an element improving quenchability and imparting temper softening resistance. Therefore, this is added to steel requiring higher strength. In this case,

addition of 0.01% or more is required. Further, if added in a large amount, Cr carbides are produced, so the upper limit was made 2.0%.

Mo is an element imparting temper softening resistance and improving the quenchability. At under 0.05%, that effect cannot be detected, while even if added at over 1.0%, the effect is saturated, so the range of addition was made 0.05% to 1.0%.

W forms carbides and can strengthen the steel by secondary precipitation hardening. If 0.05% or less, there is no effect on raising the strength, while if added over 1.0%, a large amount of carbides precipitate and conversely the mechanical properties are prevented, so this was made the upper limit.

Ni strengthens the ferrite, improves the ductility, and is also effective in improving the quenchability and improving the corrosion resistance. If less than 0.05%, this effect cannot be observed, while even if added over 2.0%, the effect is saturated in the point of the mechanical properties, so this was made the upper limit.

Cu strengthens the ferrite and is effective for improving the quenchability and improves the corrosion resistance. If under 0.01%, this effect cannot be observed, while even if added over 2.0%, the effect is saturated in the point of the mechanical properties, so this was made the upper limit. In particular, the hot ductility is reduced and defects are easily caused at the time of rolling, so it is preferable to simultaneously add Ni.

Sn has the effect of causing embrittlement of ferrite, extending the tool life, and improving the surface roughness. If less than 0.005%, this effect cannot be observed, while even if added over 2.0%, the effect is saturated in the point of the mechanical properties, so this was made the upper limit.

Zn has the effect of causing embrittlement of ferrite, extending the tool life, and improving the

surface roughness. If less than 0.0005%, this effect cannot be observed, while even if added over 0.5%, the effect is saturated in the point of the mechanical properties, so this was made the upper limit.

Ti also forms carbonitrides and strengthens the steel. Further, it is a deoxygenizing element and can form soft oxides to improve the machinability. At 0.0005% or less, that effect is not observed, while even if added over 0.1%, the effect becomes saturated. Further, Ti forms nitrides even at a high temperature and suppresses the growth of austenite grains. Therefore, the upper limit was made 0.1%. Further, Ti bonds with N to form TiN, but TiN is a hard substance and reduces the machinability. Further, it reduces the amount of N required for producing BN effective for improving machinability. Therefore, the amount of addition of Ti is preferably made 0.010% or less.

Ca is a deoxygenizing element. It not only produces soft oxides and improves the machinability, but also dissolves in the MnS and reduces the transformation ability and acts to suppress elongation of the MnS shape even with rolling and hot forging. Therefore, it is an element effective for reducing anisotropy. If less than 0.0002%, the effect is not remarkable, while even if adding 0.005% or more, not only does the yield become extremely poor, but also a large amount of hard CaO is produced and conversely the machinability is reduced. Therefore, the range is defined as 0.0002 to 0.005%.

Zr is a deoxygenizing element and produces oxides. The oxides form nuclei for precipitation of MnS and are effective for the fine, uniform diffusion of MnS. Further, it dissolves in MnS to reduce the deformation ability and acts to suppress elongation of the MnS shape even with hot rolling or hot forging. Therefore, it is an element effective for reduction of anisotropy. If less than 0.0005%, the effect is not remarkable, while even if added in 0.1% or more, not only does the yield become

extremely poor, but also large amounts of ZrO_2, ZrS, etc. are produced and conversely the machinability is reduced. Therefore, the range of addition was defined as 0.0005 to 0.1%. Note that when trying to finely disperse MnS, compound addition of Zr and Ca is preferable.

Mg is a deoxygenizing element and produces oxides. The oxides form nuclei for precipitation of MnS and are effective for the fine, uniform dispersion of MnS. It is an element effective for reduction of anisotropy. If less than 0.0003%, the effect is not remarkable, while even if added in 0.005% or more, not only does the yield become extremely poor, but also the effect is saturated. Therefore, the range of addition was defined as 0.0003 to 0.005%.

Te is an element for improving the machinability. Further, it produces MnTe or works with MnS to reduce the deformability of MnS and suppress the elongation of the MnS shapes. Therefore, it is an element effective for reducing the anisotropy. The effect is not observed if less than 0.0003%, while the effect becomes saturated if over 0.05%.

Bi and Pb are elements effective for improving machinability. Their effects are not observed at 0.005% or less, while even if added in amounts over 0.5%, not only do the effects of improvement of machinability become saturated, but also the hot forgeability drops and easily becomes a cause of defects.

Al is a deoxygenizing element and forms Al_2O_3 or AlN in steel. However, Al_2O_3 is hard, so becomes a cause of tool damage at the time of cutting and promotes wear. Therefore, the limit was made 0.015% where a large amount of Al_2O_3 is not produced. In particular, when giving priority to tool life, the limit is preferably made 0.005% or less.

Further, in the present invention, when giving priority to avoiding trouble in quenching rather than machinability, it is possible to reduce the amount of B

in the allowable range of machinability. For example, by making the amount of B in the composition of ingredients defined by the present invention 0.0005 to 0.005% and making the amount of S 0.5 to 1.0 wt%, it is possible to obtain steel superior in machinability. This is because if B is present in a large amount, the dissolved B remains, so the hardened layer becomes too deep due to the carburization quenching or other heat treatment, so by increasing the strain in the part performance or making the hardened parts brittle, it is possible to prevent various types of trouble such as quench cracks. Further, in the present invention, in cold forging, wire drawing, and other methods of working other than machining seen in free-machining steel, MnS easily becomes starting points of fractures. The mechanical properties sometimes are reduced due to the occurrence of cracks. Therefore, to secure the minimum extent of machinability of the free-machining steel, it is possible to suppress the amount of S to 0.03 to 0.5 wt% so as to suppress cold forging and high frequency surface layer cracks.

Next, the method of production of steel for causing fine dispersion of MnS and BN in the above way will be explained.

The fine dispersion of sulfides having MnS as a main ingredient and having BN compound precipitated is effective for improvement of the machinability. To get the sulfides finely dispersed, it is necessary to control the precipitation of the sulfides having MnS as a main ingredient and having BN compound precipitated. For this control, it is necessary to define the range of cooling rate during casting. With a cooling rate of 10°C/min or less, the solidification is too slow and the sulfides having MnS as a main ingredient and having BN compound precipitated end up becoming coarser and can no longer be finely dispersed. With a cooling rate of 100°C/min or more, the density of the fine sulfides produced becomes

saturated, the hardness of the billet rises, and the danger of cracks increases. The cooling rate can be easily obtained by controlling the size of the cross-section of the casting mold, the casting speed, etc. to suitable values. This may be applied to the continuous casting method and the pouring method.

The "cooling rate" referred to here means the speed at the time of cooling from the liquid phase line temperature to the solid phase line temperature in the billet thickness direction Q part. The cooling rate is found by calculation by the following equation from the secondary dendrite arm spacing of the solidified structure in the billet thickness direction after solidification.

$$Rc = \left(\frac{\lambda 2}{770}\right)^{\frac{1}{0.41}}$$

where, Rc: cooling rate (°C/min)

λ2: secondary dendrite arm spacing (μm)

That is, since the secondary dendrite arm spacing changes depending on the cooling conditions, it is possible to measure this to confirm the controlled cooling rate.

BN dissolves in austenite at 1000°C or more. At a temperature of 1000°C or less, the BN precipitated in the process from the casting to the rough rolling remains at the grain boundaries and compound precipitation as sulfides having MnS as a main ingredient and having BN compound precipitated is not possible. By rolling at a temperature of 1000°C or more in the finishing (final) rolling step at the hot rolling, the once dissolved BN easily compound precipitates as nuclei for precipitation of MnS sulfides. If finally rolling at 1000°C or less, compound precipitation of sulfides mainly comprised of BN and MnS no longer easily occurs.

Next, the method of production for obtaining a microstructure of a pearlite area ratio of 5% or less in

the present invention will be explained.

The behavior of formation of built-up edges on tools has a great effect on the cut surface roughness. Inherently, dynamatically speaking, the area right above the cutting tool is the harshest environment for materials and fracture/breakage of materials easily occur, so there should be no formation of built-up edges. In practice, built-up edges are formed due to the powerful adhesion between the tool and cut material and the structural uniformity of the cut material. Therefore, it is considered important to greatly increase the homogeneity of the microstructure of the material. As a result, the inventors discovered that the pearlite distribution, which had been considered almost irrelevant up to now, is greatly related to the homogeneity of the microstructure.

Here, the "pearlite" means a structure appearing black when etching a mirror polished surface by Nytal. "Pearlite" strictly speaking indicates ferrite and plate-shaped cementite alternately arranged. Under an opticalmicroscope, a single crystal grain appears to be seen. Further, as shown in FIG. 1, with production by normal rolling and cooling, the pearlite grains precipitate in band shapes (hereinafter referred to as "pearlite bands"). This pearlite differs in mechanical properties from the single phase ferrite of the matrix, so the deformation and fracture near the cutting edge become uneven and further the growth of built-up edges is augmented.

Therefore, the inventors adjusted the steel ingredients or thermal history to suppress the area ratio of pearlite grains of a grain size of 1 μm or more in an observation field of a measurement field of 4 mm^2 and investigate the critical region where a good surface roughness is obtained, whereupon they learned that deterioration of the surface roughness is suppressed by making the area ratio of pearlite grains of 1 μm or more

a ratio of not more than 5%. FIG. 2 shows the relationship between the area ratio of pearlite and the surface roughness.

As shown in FIG. 1, it is learned that the free-machining steel according to the present invention has extremely little of such a structure appearing black. In the present invention, the result is strictly speaking tempered martensite or tempered bainite. The possibility cannot be denied that the carbides are not pearlite (in other words, a striped structure of plate-shaped cementite and ferrite), but cementite grains. However, here, such ferrous carbides will be referred to all together as "pearlite".

Next, the method of production of free-machining steel according to the present invention will be explained.

[Thermal history quenching: 0.5°C/s from temperature of A_3 point or more to 550°C or less]

In the present invention, as the thermal history after hot rolling, it is important to cool from a temperature of above the A_3 point after hot rolling to 550°C or less by a cooling rate of at least 0.5°C/sec.

In the past, the practice had been to rapidly cool so-called low carbon free-machining steel. Low carbon free-machining steel is low in amount of C, so even with quenching, there is little change in hardness. Therefore, there is no effect on the strength/toughness due to conventional "quenching and tempering" and the fixed idea that this is not necessary for free-machining steel is not bound to. However, when pursuing homogeneity of the quality considering the nature of cutting, it is sufficient to rapidly cool from the A_3 point so as to freeze movement of C in the steel and suppress the generation of coarse cementite and pearlite occurring due to the transformation at the time of air cooling. In this case, since the hardening due to quenching is not the

objective, even if not becoming a quenched structure having a martensite structure, it is sufficient to freeze movement of C in the steel and prevent the generation of coarse cementite or pearlite. Therefore, as shown in FIG. 3, it is necessary to cool from the A_3 point to 550°C or less by a rate of 0.5°C/sec or more. When the content of the elements improving quenchability is low, a cooling rate of at least 1°C/s is preferable. If the temperature after cooling exceeds 550°C or the cooling rate is slower than 0.5, coarse pearlite is produced. In general, this is precipitated in band shapes referred to as pearlite bands. Naturally, if the alloy elements are added in large amounts as with stainless steel, even if the cooling rate is slower than 0.5°C/sec, pearlite bands are not formed. Here, however, general free-machining steel is envisioned, so the cooling rate is defined as 0.5°C/sec.

Next, in the present invention, after the above rapid cooling, heat treatment for holding at a temperature of 750°C or less may be performed to make the structure of the free-machining steel more homogeneous.

In the actual production process, to further increase the stability of the product, while the amount of C is small, it is preferable to reduce the variation in hardness in the steel. Therefore, it is possible to again hold the steel at a high temperature so as to reduce the variation in the material. First, to suppress the coarse pearlite, it is important to rapidly cool from a temperature of the A_3 point or more to 550°C or less where coarse pearlite is no longer produced. On top of this, as shown in FIG. 4, it is possible to retain the steel again at a predetermined temperature T_2°C to adjust the hardness to one satisfying user requirements and reduce the variation in hardness as well. By heating and retention at a temperature of not more than 750°C, the

steel is adjusted to a hardness satisfying the requirements of a user.

Regarding the holding temperature T_2°C, the holding temperature and the holding time should be determined so as to give a hardness satisfying the demands of the users. However, if the holding temperature T_2°C exceeds 750°C, transformation to austenite starts, so if the cooling rate at cooling again is slow, pearlite bands end up being produced. Therefore, the holding temperature T_2°C was made 750°C or less. Further, wire drawing or other secondary working is often applied at a later step, so it is preferable to adjust the temperature T_2°C so as to give a hardness suitable for handling in the later step. Regarding the holding time, industrially speaking, at 3 minutes or less, there is almost no change in hardness etc. compared with almost no holding, so the time is preferably made at least this.

Note that in industrial production, the temperature becomes uneven even in the steel due to the rolling or forging dimensions etc., so the holding time at the temperature T1°C of up to 550°C after rapid cooling for preventing coarse pearlite should also be considered. By holding at a temperature T1°C of 550°C or less after rapid cooling for preferably at least 5 minutes, uniform ferrite transformation can be promoted without relation to the dimensions of the material or segregation bands. By doing this, after this, even if raising the temperature to the holding temperature T_2°C (≤750°C)., coarse pearlite or pearlite bands will not be generated. Conversely, when the dimensions after rolling or forging are large, if the holding time at 550°C or less is shorter than 1 minute, the internal transformation does not end, so coarse pearlite or pearlite bands are produced if holding at a temperature of 550°C or more after that.

EXAMPLES

(Example 1)

The effect of the present invention will be explained by examples. Among the test materials shown in Table 1, Table 2 (continuation 1 of Table 1), Table 3 (continuation 2 of Table 1), Table 4 (continuation 3 of Table 1), Table 5 (continuation 4 of Table 1), and Table 6 (continuation 5 of Table 1), No. 13 was melted in a 270 t converter, while the rest were melted in a 2 t vacuum melting furnace, then the materials were bloomed into billets and rolled to ϕ60 mm.

In the section on heat treatment in the tables, the examples marked as "Normal." are held at 920°C for at least 10 min and then air-cooled. The examples of the invention marked as "QT" are inserted into a water tank at the rear end of the rolling line and rapidly cooled from 920°C, then held by annealing at 700°C for at least 1 hour. The pearlite area ratio was adjusted by this. In the invention examples, steels with a low amount of C can be reduced in area ratio of pearlite even with normalization.

The machinability of the material shown in Examples 1 to 81 of Table 1 to Table 6 was evaluated by a drilling test of the conditions shown in Table 7. The machinability was evaluated at the maximum cutting speed (so-called VL1000, unit m/min) enabling cutting up to a cumulative hole depth of 1000 mm.

The cut surface roughness showing the surface quality in the cutting was evaluated. The cutting conditions are shown in Table 8 and the method of evaluation (hereinafter referred to as a "plunge cutting test") is shown in FIG. 7(a) and FIG. 7(b). In the plunge cutting test, a tool is repeatedly used for cutting for a short period. With one cutting operation, the tool does not move in the longitudinal direction of the machined material, but moves toward the center of the rotating cut material, so the tool is pulled back after a short time

of cutting. The shape is basically the shape of the built-up edge of the tool transferred to the surface of the cut material. The surface roughness of the cut surface transferred is affected by formation of the built-up edges or the wear loss of the tool. The surface roughness was measured by a surface roughness meter. The 10-point surface roughness Rz (μm) was used as an indicator of the surface roughness.

Invention Examples 1 to 7 were all superior in drill life compared with Comparative Examples 76 to 81 and were good in surface roughness in plunge cutting. This is believed to be because the B caused the ferrite to be locally made brittle and the surface was smoothly created, so a good surface roughness was obtained.

The effect of improvement of surface roughness was remarkable when S was over 0.5% but an effect was seen in chip disposal even when the amount of S was smaller.

Further, an effect was recognized even when the ratio of Mn and S was the 3 or so often seen in conventional steel, but if Mn/S is made smaller, the tool life is improved more and the surface roughness is also improved. The reason is that in an environment with a large amount of B added, the fine MnS finely disperses even in the ferrite and effectively functions for both the lubrication effect and the embrittlement effect. However, if Mn/S is too small such as with Example 80, FeS is produced, so roll cracks occur. In the evaluation of the present invention, Example 70 had roll cracks, so could not be evaluated for machinability etc. at all, so the results of evaluation were not recorded in the tables.

Even if changing the amount of C somewhat (Tables 1 to 6 and Examples 37 to 75), a good tool life and cut surface roughness could be obtained by adding a large amount of B and by controlling the area ratio of pearlite.

Note that regarding the chip disposal, it is

preferable that the chips be small in curvature at the time of curling or that they be broken. Therefore, chips extending long curled 3 or more turns by a radius of curvature over 20 mm are deemed defective. Chips with a large number of turns and small radius of curvature or chips with a large radius of curvature and length not reaching 100 mm are deemed good.

Table 1

Ex.	Class	Chemical ingredients wt%																
		C	Si	Mn	P	S	B	total-N	total-O	V	Nb	Cr	Mo	W	Ni	Cu	Sn	Zn
1	Inv. ex.	0.023	0.004	1.69	0.072	0.52	0.0080	0.0079	0.0187									
2	Inv. ex.	0.011	0.015	2.05	0.077	0.72	0.0067	0.0061	0.0174									
3	Inv. ex.	0.055	0.008	1.64	0.078	0.55	0.0094	0.0096	0.0202									
4	Inv. ex.	0.058	0.013	2.36	0.077	0.75	0.0098	0.0102	0.0152									
5	Inv. ex.	0.101	0.009	1.62	0.080	0.52	0.0062	0.0055	0.0153									
6	Inv. ex.	0.090	0.009	2.14	0.088	0.75	0.0110	0.0127	0.0206									
7	Inv. ex.	0.118	0.005	1.71	0.076	0.53	0.0050	0.0040	0.0164									
8	Inv. ex.	0.117	0.007	2.10	0.079	0.73	0.0109	0.0116	0.0175									
9	Inv. ex.	0.167	0.004	1.70	0.083	0.55	0.0089	0.0090	0.0200									
10	Inv. ex.	0.174	0.007	2.19	0.072	0.75	0.0116	0.0126	0.0200									
11	Inv. ex.	0.065	0.009	1.66	0.089	0.52	0.0129	0.0142	0.0166									
12	Inv. ex.	0.055	0.004	1.70	0.074	0.58	0.0130	0.0143	0.0171									
13	Inv. ex.	0.057	0.012	1.75	0.078	0.57	0.0133	0.0147	0.0169									
14	Inv. ex.	0.058	0.013	1.84	0.084	0.59	0.0127	0.0139	0.0056									
15	Inv. ex.	0.057	0.005	1.76	0.078	0.56	0.0052	0.0042	0.0157	0.11								
16	Inv. ex.	0.053	0.005	1.70	0.078	0.60	0.0094	0.0096	0.0155		0.032							
17	Inv. ex.	0.055	0.013	1.72	0.083	0.55	0.0131	0.0146	0.0207			0.34						
18	Inv. ex.	0.050	0.014	1.91	0.078	0.58	0.0105	0.0111	0.0174				0.21					
19	Inv. ex.	0.055	0.010	1.68	0.089	0.56	0.0051	0.0042	0.0196					0.11	0.48			
20	Inv. ex.	0.057	0.013	1.49	0.082	0.51	0.0128	0.0131	0.0182							0.21		
21	Inv. ex.	0.057	0.010	1.77	0.072	0.58	0.0053	0.0043	0.0164								0.36	
22	Inv. ex.	0.050	0.005	1.75	0.087	0.54	0.0069	0.0064	0.0153									0.0040
23	Inv. ex.	0.054	0.012	1.57	0.080	0.53	0.0099	0.0104	0.0079									
24	Inv. ex.	0.050	0.009	1.81	0.089	0.55	0.0075	0.0073	0.0052									
25	Inv. ex.	0.050	0.014	1.80	0.079	0.58	0.0081	0.0079	0.0185									
26	Inv. ex.	0.057	0.014	1.72	0.081	0.53	0.0083	0.0083	0.0208									
27	Inv. ex.	0.051	0.014	1.76	0.078	0.60	0.0112	0.0119	0.0170									
28	Inv. ex.	0.055	0.003	1.67	0.090	0.55	0.0101	0.0107	0.0191									
29	Inv. ex.	0.050	0.003	1.83	0.089	0.56	0.078	0.0077	0.0210									
30	Inv. ex.	0.057	0.013	1.70	0.073	0.59	0.0080	0.0079	0.0059									
31	Inv. ex.	0.022	0.010	0.98	0.079	0.54	0.0097	0.0101	0.0190									
32	Inv. ex.	0.020	0.007	1.63	0.074	0.76	0.0123	0.0134	0.0168									
33	Inv. ex.	0.059	0.007	1.43	0.089	0.59	0.0125	0.0137	0.0184									
34	Inv. ex.	0.052	0.003	1.64	0.085	0.73	0.0063	0.0057	0.0207									
35	Inv. ex.	0.099	0.015	1.24	0.074	0.52	0.0131	0.0145	0.0190									d

Table 2 (continuation 1 of Table 1)

Ex.	Class	Chemical ingredients (wt%) Ti	Ca	Zr	Mg	Te	Bi	Pb	Al	Mn/S	Heat treat-ment	Pearlite area ratio (%)	VL1000 m/min	Surface roughness Rz (µm)	Chip disposal
1	Inv. ex.								0.0011	3.26	Normal.	1.5	147	10.5	G
2	Inv. ex.								0.0013	2.84	Normal.	0.6	155	10.4	G
3	Inv. ex.								0.0023	2.98	QT	1.9	144	7.3	G
4	Inv. ex.								0.0018	3.13	QT	0.7	157	6.6	G
5	Inv. ex.								0.0013	3.13	QT	0.7	142	7.8	G
6	Inv. ex.								0.0021	2.83	QT	2.0	152	6.2	G
7	Inv. ex.								0.0019	3.24	QT	2.0	147	6.6	G
8	Inv. ex.								0.0020	2.88	QT	1.4	157	7.4	G
9	Inv. ex.								0.0017	3.11	QT	2.6	141	6.8	G
10	Inv. ex.								0.0013	2.91	QT	0.6	145	6.5	G
11	Inv. ex.								0.0020	3.19	Normal.	5.5	130	10.8	G
12	Inv. ex.								0.0017	2.92	QT	2.3	131	6.4	G
13	Inv. ex.								0.0026	3.08	QT	2.7	126	6.3	G
14	Inv. ex.								0.0024	3.14	QT	0.8	145	7.5	G
15	Inv. ex.								0.0025	3.13	QT	2.6	146	7.7	G
16	Inv. ex.								0.0023	2.84	QT	0.7	144	6.6	G
17	Inv. ex.								0.0012	3.14	QT	2.8	147	6.8	G
18	Inv. ex.								0.0025	3.29	QT	0.5	145	7.5	G
19	Inv. ex.								0.0025	3.01	QT	1.5	147	7.0	G
20	Inv. ex.								0.0023	2.89	QT	2.5	145	7.0	G
21	Inv. ex.								0.0016	3.03	QT	3.0	146	6.9	G
22	Inv. ex.								0.0011	3.24	QT	0.8	143	7.2	G
23	Inv. ex.	0.026							0.0030	2.96	QT	1.0	143	8.0	G
24	Inv. ex.		0.0037						0.0028	3.26	QT	1.3	145	7.2	G
25	Inv. ex.			0.0037					0.0021	3.09	QT	3.0	144	6.9	G
26	Inv. ex.				0.0025				0.0027	3.25	QT	2.9	146	7.7	G
27	Inv. ex.					0.0030			0.0022	2.94	QT	1.0	144	7.9	G
28	Inv. ex.						0.16		0.0012	3.02	QT	1.2	270	7.3	G
29	Inv. ex.							0.283	0.0018	3.29	QT	1.3	170	6.4	G
30	Inv. ex.								0.0153	2.88	QT	0.8	128	7.1	G
31	Inv. ex.								0.0019	1.82	Normal.	1.4	254	10.2	G
32	Inv. ex.								0.0030	2.16	Normal.	1.4	165	11.7	G
33	Inv. ex.								0.0013	2.42	QT	2.0	156	3.9	G
34	Inv. ex.								0.0020	2.25	QT	1.4	167	4.5	G
35	Inv. ex.								0.0027	2.39	QT	0.7	153	4.1	G

Table 3 (continuation 2 of Table 1)

		Chemical ingredients wt%															
Ex.	Class	C	Si	Mn	P	S	B	total-N	total-O	V	Nb	Cr	Mo	W	Ni	Cu	Sn	Zn
36	Inv. ex.	0.091	0.006	1.54	0.079	0.77	0.0057	0.0050	0.0168									
37	Inv. ex.	0.115	0.013	1.34	0.072	0.56	0.0102	0.0107	0.0194									
38	Inv. ex.	0.118	0.011	1.61	0.083	0.76	0.0090	0.0091	0.0297									
39	Inv. ex.	0.167	0.007	1.36	0.089	0.57	0.0052	0.0042	0.0166									
40	Inv. ex.	0.171	0.006	1.42	0.089	0.71	0.0097	0.0100	0.0191									
41	Inv. ex.	0.064	0.007	1.15	0.086	0.59	0.0121	0.0132	0.0208									
42	Inv. ex.	0.053	0.003	1.00	0.074	0.53	0.0104	0.0110	0.0172									
43	Inv. ex.	0.052	0.014	1.13	0.077	0.58	0.0095	0.0098	0.0160									
44	Inv. ex.	0.056	0.014	1.04	0.089	0.54	0.0082	0.0081	0.0109									
45	Inv. ex.	0.053	0.013	1.06	0.077	0.59	0.0065	0.0059	0.0172	0.10								
46	Inv. ex.	0.050	0.007	1.14	0.088	0.57	0.0115	0.0124	0.0181		0.038							
47	Inv. ex.	0.053	0.009	1.26	0.082	0.53	0.0094	0.0097	0.0185			0.67						
48	Inv. ex.	0.058	0.006	1.13	0.076	0.54	0.0056	0.0047	0.0173				0.22					
49	Inv. ex.	0.059	0.002	1.20	0.090	0.60	0.0090	0.0091	0.0192						0.48			
50	Inv. ex.	0.057	0.005	1.31	0.082	0.56	0.0055	0.0046	0.0171							0.12		
51	Inv. ex.	0.051	0.002	1.15	0.070	0.57	0.0076	0.0072	0.0186									
52	Inv. ex.	0.050	0.012	v25	0.079	0.55	0.0085	0.0085	0.0157								0.24	0.0027
53	Inv. ex.	0.055	0.014	1.26	0.074	0.60	0.0109	0.0116	0.0058									
54	Inv. ex.	0.055	0.003	0.99	0.073	0.52	0.0070	0.0066	0.0103									
55	Inv. ex.	0.059	0.011	1.09	0.087	0.51	0.0129	0.0142	0.0175									
56	Inv. ex.	0.052	0.003	1.07	0.082	0.59	0.0063	0.0057	0.0187									
57	Inv. ex.	0.056	0.010	1.17	0.075	0.53	0.063	0.0057	0.0165									
58	Inv. ex.	0.051	0.004	1.27	0.072	0.53	0.0126	0.0138	0.0189									
59	Inv. ex.	0.056	0.010	1.12	0.080	0.56	0.0123	0.0134	0.0173									
60	Inv. ex.	0.052	0.011	1.03	0.087	0.53	0.0113	0.0121	0.0087									
61	Inv. ex.	0.056	0.008	1.46	0.079	0.54	0.0087	0.0100	0.0049									
62	Inv. ex.	0.051	0.009	1.65	0.077	0.56	0.0089	0.0099	0.0045									
63	Inv. ex.	0.056	0.006	1.45	0.082	0.54	0.0098	0.0099	0.0020									
64	Inv. ex.	0.061	0.007	1.40	0.081	0.57	0.0089	0.0091	0.0123									
65	Inv. ex.	0.071	0.011	1.10	0.002	0.55	0.0087	0.0095	0.0110									
66	Inv. ex.	0.060	0.010	1.20	0.078	0.60	0.0103	0.0124	0.0112									
67	Inv. ex.	0.060	0.009	1.06	0.077	0.53	0.0110	0.0121	0.0100									
68	Inv. ex.	0.060	0.009	1.08	0.076	0.54	0.0092	0.0112	0.0101									
69	Inv. ex.	0.070	0.008	1.40	0.086	0.56	0.0088	0.0095	0.0157									
70	Inv. ex.	0.061	0.010	1.53	0.077	0.61	0.0104	0.0124	0.0058									
71	Inv. ex.	0.060	0.060	1.35	0.077	0.54	0.0110	0.0122	0.0189									d

Table 4 (continuation 3 of Table 1)

		Chemical ingredients (wt%)									Heat treat-ment	Pearlite area ratio (%)	VL1000 m/min	Surface roughness Rz (μm)	Chip disposal
Ex.	Class	Ti	Ca	Zr	Mg	Te	Bi	Pb	Al	Mn/S					
36	Inv. ex.								0.0028	2.01	QT	3.0	168	3.5	G
37	Inv. ex.								0.0018	2.39	QT	2.2	154	3.4	G
38	Inv. ex.								0.0014	2.11	QT	2.1	170	3.7	G
39	Inv. ex.								0.0024	2.39	QT	0.5	156	3.5	G
40	Inv. ex.								0.0027	2.00	QT	0.7	168	3.9	G
41	Inv. ex.								0.0014	1.95	Normal.	5.2	135	3.9	G
42	Inv. ex.								0.0023	1.90	QT	2.5	131	3.6	G
43	Inv. ex.								0.0029	1.95	QT	2.0	133	3.1	G
44	Inv. ex.								0.0016	1.92	QT	1.0	155	3.4	G
45	Inv. ex.								0.0015	1.82	QT	2.8	156	3.7	G
46	Inv. ex.								0.0026	2.00	QT	1.9	155	3.3	G
47	Inv. ex.								0.0012	2.39	QT	1.4	156	3.7	G
48	Inv. ex.								0.0026	2.09	QT	0.6	155	3.6	G
49	Inv. ex.								0.0012	2.00	QT	2.8	154	4.1	G
50	Inv. ex.								0.0030	2.31	QT	1.4	156	4.2	G
51	Inv. ex.								0.0019	2.02	QT	2.6	155	3.3	G
52	Inv. ex.								0.0029	2.27	QT	0.8	153	4.8	G
53	Inv. ex.	0.036							0.0016	2.12	QT	1.3	156	4.7	G
54	Inv. ex.		0.0033						0.0017	1.89	QT	2.5	156	4.5	G
55	Inv. ex.			0.0035					0.0024	2.14	QT	2.1	154	3.0	G
56	Inv. ex.				0.0020				0.0013	1.82	QT	2.6	154	4.3	G
57	Inv. ex.					0.0061			0.0022	2.21	QT	2.4	154	3.6	G
58	Inv. ex.						0.16		0.0017	2.37	QT	2.8	182	2.6	G
59	Inv. ex.							0.266	0.0031	2.02	QT	2.5	189	2.2	G
60	Inv. ex.								0.0280	1.96	QT	1.9	136	3.5	G
61	Inv. ex.								0.0010	2.70	QT	2.3	146	6.5	G
62	Inv. ex.	0.005		0.0009					0.0021	2.95	QT	3.4	145	6.4	G
63	Inv. ex.		0.0022	0.0025					0.0010	2.68	QT	2.9	145	6.6	G
64	Inv. ex.		0.0018	0.0012					0.0011	2.45	QT	3.0	139	6.5	G
65	Inv. ex.								0.0016	2.00	QT	2.5	172	7.3	G
66	Inv. ex.			0.0030					0.0015	2.00	QT	2.8	134	6.5	G
67	Inv. ex.								0.0012	2.00	QT	3.6	131	8.9	G
68	Inv. ex.		0.0025	0.0015					0.0019	2.00	QT	2.1	130	6.1	G
69	Inv. ex.								0.0016	2.50	QT	3.9	135	9.9	G
70	Inv. ex.								0.0017	2.51	QT	2.3	133	7.2	G
71	Inv. ex.			0.0025					0.0010	2.50	QT	3.9	132	6.5	G

Table 5 (continuation 4 of Table 1)

		Chemical ingredients wt%																
Ex.	Class	C	Si	Mn	P	S	B	total-N	total-O	V	Nb	Cr	Mo	W	Ni	Cu	Sn	Zn
72	Inv. ex.	0.059	0.009	1.38	0.075	0.55	0.0092	0.0132	0.0173									
73	Inv. ex.	0.069	0.009	1.62	0.076	0.54	0.0089	0.0095	0.0160									
74	Inv. ex.	0.062	0.006	1.80	0.090	0.60	0.0100	0.0106	0.0181									
75	Comp. ex.	0.058	0.002	1.65	0.079	0.55	0.0110	0.0122	0.0173									
76	Comp. ex.	0.045	0.007	1.00	0.084	0.35	0.0076	0.0074	0.0183									
77	Comp. ex.	0.050	0.005	1.79	0.074	0.59	0.0067	0.0062	0.0180									
78	Comp. ex.	0.049	0.008	0.96	0.077	0.34	0.0129	0.0141	0.0205									
79	Comp. ex.	0.055	0.009	1.78	0.080	0.59	-	0.0123	0.0151									
80	Comp. ex.	0.047	0.011	0.48	0.085	0.53	0.0089	0.0090	0.0167									
81	Comp. ex.	0.048	0.008	0.93	0.089	0.53	-	0.0139	0.0151									

Table 6 (continuation 1 of Table 1)

Ex.	Class	Chemical ingredients (wt%) Ti	Ca	Zr	Mg	Te	Bi	Pb	Al	Mn/S	Heat treat-ment	Pearlite area ratio (%)	VL1000 m/min	Surface roughness Rz (μm)	Chip disposal
72	Inv. ex.								0.0016	2.51	QT	2.2	132	7.2	G
73	Inv. ex.		0.0016	0.0010					0.0006	3.00	QT	2.6	134	9.1	G
74	Inv. ex.								0.0010	3.00	QT	1.9	130	8.2	G
75	Inv. ex.		0.0022	0.0017					0.0009	2.00	QT	2.9	130	6.4	G
76	Comp. ex.								0.0012	2.90	Normal.	5.8	97	17.0	P
77	Comp. ex.								0.0013	3.05	Normal.	5.8	119	21.1	G
78	Comp. ex.								0.0017	2.83	Normal.	5.8	100	24.4	G
79	Comp. ex.								0.0011	3.03	Normal.	5.3	119	24.2	G
80	Comp. ex.								0.0013	0.90	-	-	-	-	-
81	Comp. ex.								0.0027	2.81	Normal.	5.9	117	24.5	P

Table 7

Cutting conditions	Drill	Others
Cutting speed: 80 m/min Feed: 0.05 mm/rev Insoluble machining oil	ϕ5 mm NACHI ordinary drill, projection amount 60 mm	Hole depth: 15 mm Tool life: Until breakage

Table 8

Cutting conditions	Tool	Others
Cutting speed: 80 m/min Feed: 0.05 mm/rev Insoluble machining oil	SKH57 equivalent Rake angle: 20° Relief angle: 6°	Projection Evaluation timing: 200 cycles

(Example 2)

Parts of the test materials shown in Table 9, Table 10 (continuation 1 of Table 9), Table 11 (continuation 2 of Table 9), Table 12 (continuation 3 of Table 9), Table 13 (continuation 4 of Table 9), and Table 14 (continuation 5 of Table 9) were produced by a 270 t converter, then casted at a cooling rate of 10 to 100°C/min. The billet was bloomed, then further rolled to ϕ50 mm. Further, the rest was melted in a 2 t vacuum melting furnace and rolled to ϕ50 mm. At this time, the cooling rate of the billet was adjusted by changing the cross-sectional dimensions of the casting mold. The machinability of the material was evaluated by a drilling test of the conditions shown in Table 7 and plunge cutting of the conditions shown in Table 8. The drill boring test is a method evaluating the machinability by the maximum cutting speed (so-called VL1000, unit m/min) enabling cutting up to a cumulative hole depth of 1000 mm. Plunge cutting is a method of evaluating the surface roughness by transferring a tool shape by a cutting tool. The experimental method is shown in FIG. 7(a) and FIG. 7(b). In this experiment, the surface roughness in the

case of cutting 200 grooves was measured by a surface roughness meter. The 10-point surface roughness Rz (unit: μm) was used as an indicator of the surface roughness.

The density of the sulfides mainly comprised of Mns of dimensions of a circle equivalent diameter of 0.1 to 0.5 μm density was measured by taking a sample by the extraction replica method from the Q part of the cross-section parallel to the rolling direction after rolling to ϕ50 mm and observing it under a transmission type electronmicroscope. The measurement was conducted by observing at least 40 fields of 80 μm^2 at X10000 power and converting to the number of sulfides mainly comprised of MnS per square mm. The steels with the calculated values of equation (1) of Table 10, Table 12, and Table 14 are development steels satisfying the present invention.

As shown in FIG. 2(a) and FIG. 2(b), MnS of a size which cannot be confirmed at the opticalmicroscope level is clearly different in dimensions and density in the inventions of the examples and comparative examples by observation of TEM replicas.

Note that the cutting resistance and chip disposal of Table 10, Table 12, and Table 14 are as follows. The cutting resistance was measured by attaching a piezoelectric dynamometer (made by Kistler) to the turret of a lathe, setting the tool on it to give the same position as normal cutting, and performing plunge cutting. Due to this, measurement is possible using the main force component and back force component applied to the tool as voltage signals. The cutting speed, feed speed, and other cutting conditions are similar to those for evaluation of the cut surface roughness.

Regarding chip disposal, it is preferable that the chips be small in curvature at the time of curling or that they be broken. Therefore, chips extending long curled 3 or more turns by a radius of curvature over 20 mm are deemed defective. Chips with a large number of

turns and small radius of curvature or chips with a large radius of curvature and length not reaching 100 mm are deemed good.

In machinability, the examples of the present invention were superior in drill tool life compared with any of the comparative examples and were good in surface roughness at plunge cutting. In particular, it was possible to obtain an extremely superior value of surface roughness by the effect of compound precipitation of the fine MnS and BN.

Table 9

Cl	St'l	Chemical ingredients (wt%)																	
		C	Si	Mn	P	S	Total N	Total O	B	V	Nb	Cr	Mo	W	Ni	Cu	Su	Zn	Ti	Ca
Inv. ex.	1	0.051	0.012	0.83	0.076	0.56	0.0140	0.0202	0.0070											
	2	0.031	0.003	0.76	0.084	0.52	0.0124	0.0153	0.0066											
	3	0.021	0.005	1.05	0.079	0.54	0.0044	0.0177	0.0061											
	4	0.052	0.010	0.91	0.075	0.47	0.0148	0.0157	0.0059											
	5	0.053	0.009	1.45	0.071	0.61	0.0125	0.0184	0.0079											
	6	0.021	0.012	1.31	0.077	0.62	0.0051	0.0207	0.0079											
	7	0.053	0.005	1.72	0.077	0.60	0.0044	0.0202	0.0077											
	8	0.021	0.014	1.31	0.081	0.46	0.0113	0.0187	0.0068											
	9	0.057	0.013	1.07	0.080	0.54	0.0126	0.0181	0.0070	0.10										
	10	0.055	0.008	1.10	0.078	0.56	0.0051	0.0175	0.0079		0.005									
	11	0.052	0.011	1.17	0.079	0.59	0.0082	0.0202	0.0056			0.41								
	12	0.051	0.006	1.15	0.080	0.58	0.0121	0.0209	0.0066				0.36							
	13	0.029	0.010	0.93	0.089	0.48	0.0118	0.0194	0.0053					0.10	0.23					
	14	0.059	0.012	0.90	0.077	0.46	0.0110	0.0190	0.0057						0.11	0.28				
	15	0.055	0.005	0.98	0.076	0.50	0.0069	0.0208	0.0066							0.28				
	16	0.021	0.008	1.03	0.087	0.52	0.0078	0.0200	0.0078								0.23			
	17	0.031	0.010	0.90	0.088	0.48	0.0067	0.0158	0.0054								0.03	0.0065		
	18	0.052	0.004	0.89	0.078	0.45	0.0071	0.0181	0.0073									0.0100		
	19	0.053	0.011	0.95	0.086	0.49	0.0120	0.0190	0.0073										0.038	
	20	0.023	0.008	1.04	0.077	0.53	0.0135	0.0205	0.0079											0.0018
	21	0.039	0.002	1.09	0.061	0.55	0.0128	0.0151	0.0062											
	22	0.051	0.008	1.05	0.076	0.54	0.0102	0.0208	0.0051											
	23	0.053	0.008	1.11	0.083	0.57	0.0077	0.0162	0.0078											
	24	0.029	0.010	0.98	0.088	0.50	0.0065	0.0184	0.0057											
	25	0.053	0.004	1.13	0.080	0.57	0.0169	0.0109	0.0066											
	26	0.051	0.011	1.04	0.077	0.53	0.0092	0.0160	0.0076											
	27	0.065	0.005	0.67	0.087	0.46	0.0152	0.0165	0.0050											
	28	0.064	0.010	0.75	0.082	0.52	0.0048	0.0161	0.0075											
	29	0.111	0.010	1.03	0.071	0.53	0.0053	0.0200	0.0056											
	30	0.055	0.014	1.12	0.080	0.57	0.0064	0.0162	0.0075											

Table 10 (continuation 1 of Table 9)

Class	St'l	Chemical ingredients (wt%)						Cooling speed at casting (°C/min)	Rolling finishing temp. (°C)	TEM replica MnS density (/mm²)	BN comp. prec. rate (%)	VL1000 (m/min)	Surface roughness (μm Rz)	Cutting resistance (N)		Chip disp.	Cal. val. of eq. (1)
		Zr	Mg	Te	Bi	Pb	Al							Back force comp.	Main force comp.		
Inv. ex.	1						0.002	100	1097	353565	20	145	6.7	65	390	G	0.09
	2						0.004	72	1073	249998	15	149	5.4	73	342	G	0.06
	3						0.004	64	1020	328542	29	142	7.0	86	358	G	0.13
	4						0.003	55	1035	262595	25	148	4.1	64	383	G	0.14
	5						0.003	47	1029	166778	16	149	8.9	87	385	G	0.19
	6						0.002	34	1055	178854	29	133	8.4	72	352	G	0.23
	7						0.002	37	1079	148887	12	142	7.4	71	332	G	0.16
	8						0.001	92	1031	305248	28	140	7.9	67	339	G	0.07
	9						0.004	66	1176	299171	18	131	5.2	84	331	G	0.05
	10						0.004	14	1104	82353	22	136	5.9	90	350	G	0.06
	11						0.005	37	1098	186895	16	141	8.8	80	368	G	0.29
	12						0.002	28	1181	142954	28	140	4.6	83	342	G	0.16
	13						0.002	82	1173	384851	27	144	4.5	72	381	G	0.21
	14						0.005	88	1096	394447	20	132	4.4	62	336	G	0.17
	15						0.003	97	1145	432218	18	141	5.0	67	367	G	0.05
	16						0.003	67	1101	260532	26	139	4.4	72	380	G	0.01
	17						0.001	39	1165	120677	22	143	6.7	62	342	G	0.19
	18						0.003	77	1116	266882	12	137	4.2	78	355	G	0.05
	19						0.002	87	1012	407007	21	135	5.8	69	377	G	0.02
	20	0.0020					0.002	86	1001	333280	11	148	6.1	73	346	G	0.01
	21		0.0038				0.003	92	1153	366185	12	147	4.5	69	380	G	0.13
	22	0.0029	0.0026				0.002	54	1103	303000	23	138	5.3	69	367	G	0.26
	23			0.0020			0.006	82	1124	285444	24	147	4.3	62	379	G	0.08
	24				0.256		0.005	38	1129	243854	10	134	6.1	74	360	G	0.15
	25					0.16	0.002	80	1018	365823	22	145	5.6	66	332	G	0.13
	26						0.001	95	1199	309532	10	139	4.7	75	387	G	0.02
	27						0.002	77	1131	255448	13	134	6.7	83	363	G	0.28
	28						0.003	20	1173	146979	20	145	4.3	84	366	G	0.01
	29						0.002	47	1089	260872	18	145	8.9	66	332	G	0.17
	30						0.004	91	1133	281096	22	145	6.9	65	369	G	0.09

Table 11 (continuation 2 of Table 9

Cl.	St'l	Chemical ingredients (wt%)																		
		C	Si	Mn	P	S	Total N	Total O	B	V	Nb	Cr	Mo	W	Ni	Cu	Su	Zn	Ti	Ca
I	31	0.116	0.003	1.37	0.073	0.55	0.0119	0.0208	0.0078											
n	32	0.077	0.004	1.39	0.070	0.56	0.0089	0.0168	0.0060											
v.	33	0.071	0.007	1.32	0.084	0.46	0.0135	0.0154	0.0063											
	34	0.102	0.013	1.36	0.088	0.48	0.0140	0.0177	0.0077											
e	35	0.054	0.003	1.69	0.073	0.56	0.0133	0.0163	0.0067											
x.	36	0.056	0.007	1.57	0.075	0.55	0.0139	0.0183	0.0060											
	37	0.159	0.011	0.74	0.084	0.51	0.0115	0.0194	0.0054											
	38	0.176	0.004	0.73	0.072	0.50	0.0147	0.0167	0.0059											
	39	0.177	0.014	0.97	0.071	0.49	0.0053	0.0177	0.0075											
	40	0.182	0.004	1.04	0.080	0.53	0.0105	0.0166	0.0053											
	41	0.150	0.004	1.29	0.073	0.49	0.0124	0.0189	0.0056											
	42	0.199	0.012	1.42	0.087	0.57	0.0120	0.0174	0.0075											
	43	0.189	0.015	1.30	0.073	0.45	0.0104	0.0160	0.0076											
	44	0.165	0.010	1.33	0.080	0.46	0.0148	0.0209	0.0067											
	45	0.171	0.007	1.34	0.077	0.47	0.0177	0.0156	0.0078											
	46	0.191	0.009	1.56	0.089	0.55	0.0112	0.0153	0.0065											
	47	0.051	0.008	1.03	0.086	0.51	0.0110	0.0050	0.0072											
	48	0.031	0.003	1.03	0.078	0.52	0.0100	0.0185	0.0115										0.005	
	49	0.053	0.004	1.02	0.080	0.53	0.0103	0.0159	0.0078											0.0020
	50	0.084	0.008	1.01	0.082	0.52	0.0084	0.0040	0.0112											0.0019
	51	0.065	0.006	1.01	0.081	0.46	0.0110	0.0152	0.0100											
	52	0.057	0.008	1.03	0.080	0.53	0.0109	0.0156	0.0132											
	53	0.049	0.008	1.05	0.082	0.50	0.0112	0.0125	0.0112											
	54	0.079	0.010	0.99	0.072	0.47	0.0113	0.0145	0.0108											
	55	0.082	0.008	1.34	0.080	0.67	0.0106	0.0121	0.0035											
	56	0.064	0.010	1.12	0.079	0.50	0.0112	0.0134	0.0105											
	57	0.055	0.010	1.15	0.074	0.49	0.0108	0.0127	0.0114										0.006	
	58	0.070	0.010	1.20	0.071	0.51	0.0112	0.0104	0.0112											0.0015
	59	0.076	0.009	0.81	0.077	0.30	0.0111	0.0147	0.0121											0.0018
	60	0.081	0.008	1.34	0.079	0.64	0.0109	0.0156	0.0121											

Table 12 (continuation 3 of Table 9)

Cl.	St'1	Chemical ingredients (wt%)						Cooling speed at casting (°C/min)	Rolling finishing temp. (°C)	TEM replica MnS density (/mm²)	BN comp. prec. rate (%)	VL1000 (m/min)	Surface rough-ness (μmRz)	Cutting resistance (N)		Chip disp.	Cal. val. of eq. (1)
		Zr	Mg	Te	Bi	Pb	Al							Back force comp.	Main force comp.		
Inv. ex.	31						0.003	16	1057	85221	14	132	7.6	82	386	G	0.04
	32						0.002	45	1120	142738	15	147	7.9	79	338	G	0.18
	33						0.002	16	1017	61245	10	149	7.0	65	371	G	0.11
	34						0.003	78	1110	272514	28	133	7.8	70	349	G	0.01
	35				0.17		0.002	77	1168	262609	15	135	4.9	63	344	G	0.10
	36					0.298	0.002	21	1106	81541	18	146	5.0	61	335	G	0.15
	37						0.003	52	1100	194907	16	145	5.5	73	351	G	0.19
	38						0.002	59	1085	301851	15	132	6.9	80	378	G	0.13
	39						0.001	22	1191	125206	30	145	6.7	74	382	G	0.01
	40						0.003	74	1125	262061	11	135	5.0	75	358	G	0.21
	41						0.003	23	1036	108319	19	144	7.6	67	331	G	0.16
	42						0.002	50	1163	170214	17	133	8.7	87	379	G	0.09
	43						0.003	11	1171	50750	25	137	6.7	67	366	G	0.04
	44						0.004	69	1098	234200	10	138	7.0	83	388	G	0.07
	45				0.286		0.004	53	1095	289829	14	148	6.8	89	332	G	0.02
	46					0.20	0.003	53	1089	186791	22	147	6.0	80	333	G	0.10
	47						0.002	89	1011	416010	26	140	5.5	66	354	G	0.02
	48	0.0018					0.001	85	1000	333350	13	144	6.2	72	344	G	0.35
	49	0.0021					0.001	86	1003	353921	12	139	6.1	70	352	G	0.02
	50	0.0010					0.003	20	1173	146542	22	145	4.5	84	366	G	0.29
	51						0.002	78	1130	253458	21	145	4.0	81	352	G	0.23
	52						0.001	79	1126	262337	20	140	4.1	82	362	G	0.77
	53						0.001	65	1002	189562	20	140	4.1	82	345	G	0.28
	54						0.001	82	1121	252563	21	135	4.4	84	361	G	0.23
	55						0.001	54	1056	164512	20	140	4.1	81	361	G	1.02
	56						0.001	77	1096	132654	27	135	5.1	82	375	G	0.17
	57	0.0012					0.001	78	1059	192563	14	135	5.6	84	375	G	0.32
	58	0.0014					0.001	62	1100	189562	15	135	5.7	81	352	G	0.29
	59	0.0011					0.001	50	1058	123654	16	140	4.9	86	362	G	1.11
	60						0.001	51	1123	165842	14	135	5.2	83	374	G	0.78

Table 13 (continuation 4 of Table 9)

Cl.	St'l	Chemical ingredients (wt%)																	
		C	Si	Mn	P	S	Total N	Total O	B	V	Nb	Cr	Mo	W	Ni	Cu	Su	Zn	Ti	Ca
Inv. ex.	61	0.060	0.008	1.45	0.080	0.65	0.0112	0.0132	0.0050											
	62	0.061	0.011	0.75	0.076	0.33	0.0104	0.0112	0.0110											
	63	0.068	0.008	1.51	0.081	0.58	0.0132	0.0156	0.0110											
	64	0.072	0.009	0.71	0.072	0.30	0.0122	0.0125	0.0110											
	65	0.082	0.008	0.88	0.077	0.34	0.0118	0.0135	0.0043											
Comp. ex.	66	0.081	0.003	0.93	0.077	0.31	0.0099	0.0170												
	67	0.072	0.010	0.75	0.076	0.24	0.0069	0.0184												
	68	0.097	0.017	0.90	0.072	0.30	0.0095	0.0175												
	69	0.067	0.006	0.92	0.077	0.30	0.0142	0.0168												
	70	0.069	0.011	0.843	0.088	0.28	0.0130	0.0177												
	71	0.089	0.012	0.37	0.070	0.12	0.0103	0.0191												
	72	0.092	0.019	0.31	0.079	0.11	0.0166	0.0174												
	73	0.096	0.014	0.40	0.089	0.13	0.0173	0.0177												
	74	0.064	0.035	0.94	0.070	0.01	0.0133	0.0158	0.0035											
	75	0.079	0.036	0.50	0.071	0.17	0.0126	0.0178	0.0013											
	76	0.090	0.012	0.34	0.081	0.12	0.0167	0.0183	0.0030											
	77	0.089	0.015	0.98	0.073	0.32	0.0134	0.0205	0.0038											

Table 14 (continuation 5 of Table 9)

Class	St'l	Chemical ingredients (wt%)						Cooling speed at casting (°C/min)	Rolling finishing temp. (°C)	TEM replica MnS density (/mm²)	BN comp. prec. rate (%)	VL1000 (m/min)	Surface rough-ness (μmRz)	Cutting resistance (N)		Chip disp.	Cal. val. of eq. (1)
		Zr	Mg	Te	Bi	Pb	Al							Back force comp.	Main force comp.		
Inv. ex.	61						0.002	71	1005	212365	16	140	5.0	81	366	G	0.61
	62						0.001	70	1022	196354	14	140	6.2	86	379	G	0.71
	63						0.002	56	1006	156235	20	145	5.1	82	354	G	0.35
	64						0.001	69	1215	142562	19	140	4.9	83	362	G	0.89
	65						0.001	72	1231	212365	17	135	5.1	85	374	G	0.79
Comp. ex.	66						0.004	6	865	232	0	92	17.7	173	451	P	2.36
	67						0.004	7	820	194	0	95	19.4	169	512	P	2.82
	68						0.002	5	784	214	0	66	18.2	188	452	G	2.45
	69						0.001	2	831	53	0	83	15.5	201	466	G	2.41
	70						0.002	5	814	192	0	99	15.4	217	497	P	2.54
	71						0.001	8	763	227	0	73	18.7	210	454	P	4.03
	72						0.003	4	799	161	0	79	18.5	155	524	G	4.24
	73						0.004	3	821	141	0	66	19.9	189	464	G	3.95
	74						0.002	8	844	207	0	75	17.8	152	500	P	4.39
	75						0.001	2	774	57	0	93	16.9	209	481	P	3.02
	76						0.003	6	891	180	1	93	17.9	217	486	G	3.07
	77						0.004	6	827	154	1	83	15.3	199	523	G	1.10

INDUSTRIAL APPLICABILITY

As explained above, the present invention enables use for automobile parts and general machinery parts have superior properties of tool life and cut surface roughness at the time of cutting and disposal of chips.